

Date: Thursday, 2/22/2007 2:57:37 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SPACER	
Job Number	: 30813A				
Estimate Number	: 10352				
P.O. Number	: N/A		Part Number	: D2280	
This Issue	2/22/2007	S.O. No. :	Drawing Number	: D2280 REV D	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: / /		Drawing Revision	: D	
Previous Run	: 29922A		Material	: N/A	
Written By	: <i>[Signature]</i>		Due Date	: 2/6/2007	
Checked & Approved By	: <i>[Signature]</i> 07.02.23		Qty:	20	Um: Each
Comment	: Est Rev:A New Issue 05-11-07 JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0250X01000	6061-T6 Bar .25" x 1.0"	
		Comment: Qty.: 0.2975 f(s)/Unit Total : 5.9493 f(s) Material: 6061-T6 (QQ-A-250/8) 0.25" Thick (M6061T6B0.250x1.000) identify as D2280 Batch: <i>M19059</i>	<i>SD 07.03.06</i>
2.0	SHEAR	SHEAR	
		Comment: SHEAR Cut blank: (3.400") +/-0.020"	<i>SD 07.03.07 20</i>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1	
		1-Machine per folio D2280 and Dwg D2280	
		2-Deburr Then Tumble	<i>SD 07.03.07 20</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>SD 07.03.07 20</i>
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<i>J.F. 07/03/07 20</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/03/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 30813A

Part Number: D2280

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



20x

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-F

07/03/07

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/03/08 (20) 00

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07/03/08 (20) 00

9.0 QC21

FINAL INSPECTION/W/O RELEASE



20

Comment: FINAL INSPECTION/W/O RELEASE

07/03/08

Job Completion



U 07.03.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30813A
Description: Spacer	Part Number:	D2280
Inspection Dwg: D2280	Rev: D	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article Prototype

Measured by:	SD	Audited by:	CP	Prototype Approval:	N/A
Date:	07.03.07	Date:	07.03.07	Date:	N/A

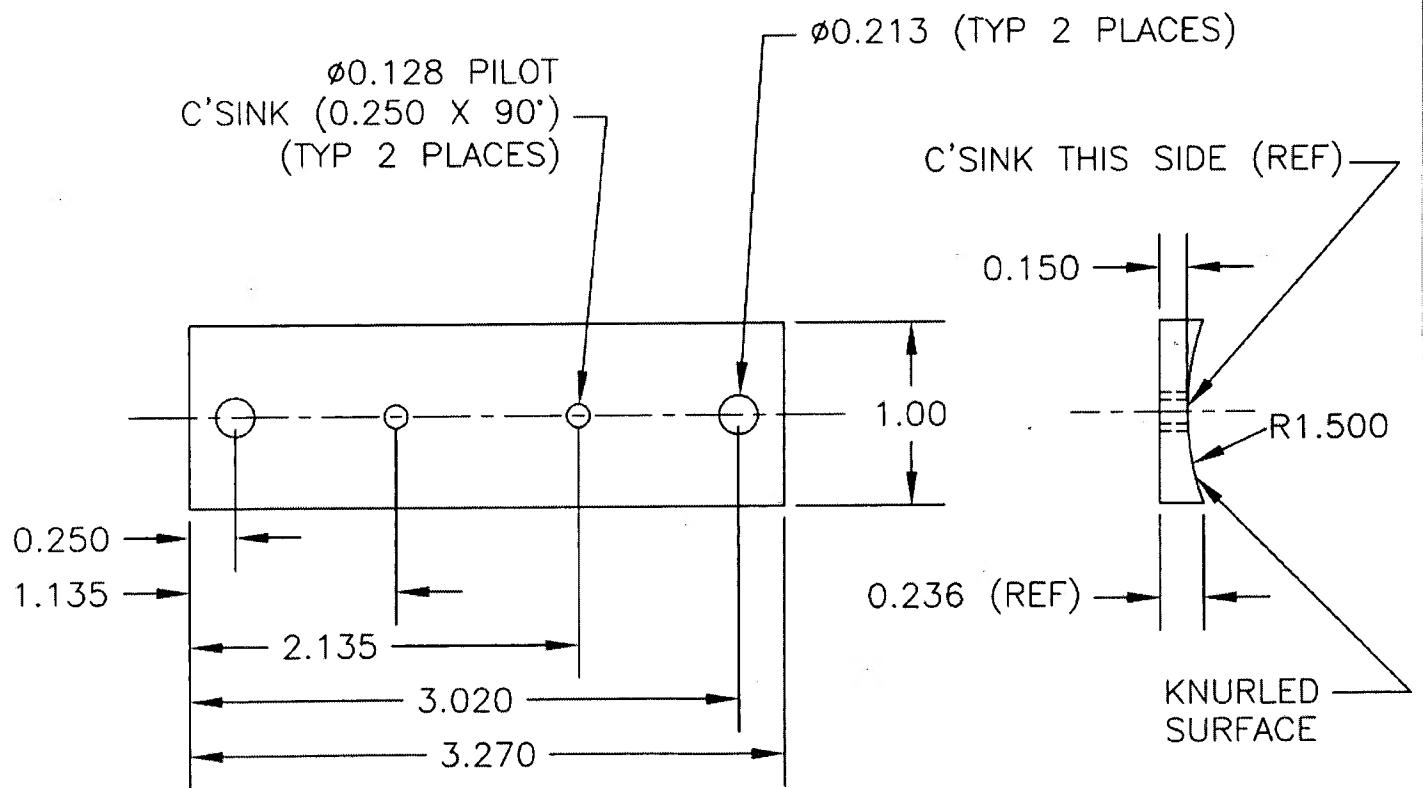
Rev	Date	Change	Revised by	Approved
A	04.10.12	New Issue P/O D2582	KJ/JLM	
B	06.03.08	Dwg Rev changed	KJ/JLM	





DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. D
		D2280	SHEET 1 OF 1
DATE		TITLE	SCALE
05.11.14		SPACER	1:1
A	94.10.14	NEW ISSUE	
B	95.03.22	MATERIAL CHANGE, 0.15 WAS 0.20	
C	98.09.29	0.188 DIA HOLE CHANGED TO 0.213	
D	05.11.14	ADD FINISHING NOTE	

RELEASED  
05.11.28



#### D2280 SPACER

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8) BAR, 0.250 X 1.000 (REF. DART SPEC M6061T6B1.000X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER  
NO. 30813A

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